

Date: Friday, 11/18/2005 3:18:16 PM  
User: Linda Lacelle

## Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)  
Job Number : 24830 - 2  
Estimate Number : 10533  
P.O. Number : N/A Part Number : D2573  
This Issue : 11/18/2005 S.O. No. : N/A Drawing Number : D2573 REV D  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : MACHINED PARTS Drawing Revision : D  
Previous Run : 24434 Material : N/A  
Written By : See comment below Due Date : 12/20/2005 Qty: 4 Um: Each  
Checked & Approved By : See comment below  
Comment : Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ

## Additional Product

Job Number



Seq. #:

Machine Or Operation:

Description :

1.0

D6101007

7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B24830 X4

J.G. / M8

06/01/09

4

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No: B24830 Double check by: En 06/01/09

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per-M8 06/01/09  
Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets -M8 06/01/09

4-Deburr and remove all machining marks -M8 06/01/09

N/A 5-Tumble to remove sharp edges. J.G.

J.G.

J.G.

4

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 &amp; D2574

J.G.

06/01/10

4



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LS Date: 06/01/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Key

1. 1000 ft. deep

2. 1000 ft. deep

3. 1000 ft. deep

4. 1000 ft. deep

5. 1000 ft. deep

6. 1000 ft. deep

7. 1000 ft. deep

8. 1000 ft. deep

9. 1000 ft. deep

10. 1000 ft. deep

11. 1000 ft. deep

12. 1000 ft. deep

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 24839

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

5.6 06/01/10

Description:

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.6 06/01/10

4

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BC 06-01-10

4

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-11

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.0,5.1) as per QSI 005 4.3

MA 06 01 16 4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PO 06/01/17 4

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 374

PO 06/01/17 4

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5.6 06/01/18 ⑧ ⑨ 06/01/18

Job Completion







AEROSPACE LTD		Work Order:	
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	✓	✓	✓	✓	
B	1.745	1.755		1.746	1.751	1.752	1.751		
C	3.495	3.505		3.495	3.502	3.501	3.501		
D	1.745	1.755		1.746	1.750	1.752	1.751		
E	7.990	8.010		8.002	8.003	8.002	8.003		
F	0.490	0.510		0.500	0.507	0.503	0.508		
G	0.257	0.262	DT8683	0.257	✓	✓	✓	✓	
H	0.375	0.380	DT8684	0.376	✓	✓	✓	✓	
I	0.490	0.510		0.498	0.507	0.503	0.498		
J	1.174	1.184		1.179	1.179	1.180	1.180		
K	0.558	0.578		0.564	0.578	0.565	0.566		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.371	1.370	1.370	1.370		
N	2.495	2.505		2.501	2.500	2.501	2.500		
O	4.119	4.129		4.127	4.125	4.121	4.122		
P	0.115	0.135		0.131	0.130	0.126	0.127		
Q	0.115	0.135		0.120	0.128	0.133	0.135		
R	0.240	0.260		0.255	0.253	0.248	0.252		
S	0.115	0.135		0.134	0.135	0.128	0.124		
T	0.178	0.198		0.187.5	0.188	0.185	0.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		0.247	0.246	0.242	0.242		
W	0.115	0.135		0.116	0.135	0.133	0.130		
X	0.308	0.313							
Y	0.760	0.765							
Z	0.352	0.372		0.365	0.365	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.635	0.631	0.633	0.635		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.260	0.258	0.249		
AE	1.500	1.520		1.500	1.506	1.508	1.511		
AF	0.115	0.135		0.118	0.128	0.125	0.130		
AG	0.240	0.280		0.255	0.270	0.270	0.255		
AH	0.240	0.260		0.257	0.256	0.255	0.255		
AI	2.000	2.020		2.000					
AJ	0.023	0.043							
Accept/Reject									

Measured by:	3.6
Date:	06.01.10

Audited by:	36
Date:	06.01.10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED  
11/05/12-09





# Job Costing Report

Hart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	: 0024839	Department Code:	
Project Name	: D2573	Burden Flags	: NNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2573	Invoice Number	:
Description	: Saddle, Aft, Out	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Bq'd	: 12	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-20-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
Overhead Hours	0.00	0.00	0.00		
Overhead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

